

# Work Order ID 52805

October 14, 2009 11:36:10 AM



Page 1

Item ID:	D3798-042	Accept		Setup	Start	
Revision ID:	B				Stop	
Item Name:	Spacepod Floor					
Start Date:	10/14/2009	Start Qty:	3.00			
Required Date:	10/19/2009	Req'd Qty:	3.00			
Reference:						
				Cust Item ID:		
				Customer:		

Approvals:	Process Plan:	<u>mf</u>	Date:	<u>09-10-14</u>	Tooling:		Date:		Run	Start	
	QC:		Date:		SPC (Y/N):		Date:			Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
<b>Draw Nbr</b>	<b>Revision Nbr</b>								
D3798	Rev B								
100	FLOW WATER JET	0.00							
	Waterjet								
FLOW CNC Waterjet	<b>Memo</b>	0.00							
	1-Cut as per Dwg D3798-2								
	***same flat paterne as D3798-1***								
	Dwg Rev: <u>B</u>								
	Prog Rev: <u>B</u>								
	2-Deburr if necessary								
110	QC2- Inspect parts off machine FAI/FAIB	0.00							
	QC								
Quality Control	<b>Memo</b>	0.00							
	***template D3798-IT1***								

18 9-10-15

③

18 9-10-15

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Work Order ID 52805

October 14, 2009 11:36:10 AM



Page 2

Item ID:	D3798-042	Accept		Setup	Start	
Revision ID:	B				Stop	
Item Name:	Spacepod Floor					
Start Date:	10/14/2009	Start Qty:	3.00		Cust Item ID:	
Required Date:	10/19/2009	Req'd Qty:	3.00		Customer:	
Reference:						

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 	QC8- Inspect parts - second check	0.00							
QC Quality Control	Memo ***template D3798-1T1***	0.00	=> 807/01/15			(X3)	/		
130 	Small Fab	0.00							
Small Fab	Memo 1- C'sink as per dwg D3798-2 2- Deburr if necessary	0.00							
									8/309/10/15 (3)
140 	QC5- Inspect part completeness to step on W/O	0.00							
QC Quality Control	Memo	0.00	=> 807/01/15			(X3)	/		

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Work Order ID 52805

October 14, 2009 11:36:10 AM



Page 3

Item ID: D3798-042

Accept



Setup Start



Revision ID: B

Stop



Item Name: Spacepod Floor

Start Date: 10/14/2009 Start Qty: 3.00



Cust Item ID:

Required Date: 10/19/2009 Req'd Qty: 3.00

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150	Chemical Conversion Coat per QSI005 4.1	0.00							
	HandFinish	0.00	md	09/10/16		X3			
	Hand Finishing								
160	QC3- Inspect Part Finish	0.00							
	QC	0.00	BL	09-10-16		③			
	Quality Control								
170		0.00							
	Small Fab	0.00							
	Small Fab								
	1- Assemble D3798-2 to D3798-5 as per dwg								

09/10/16 ③

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Work Order ID 52805

October 14, 2009 11:36:10 AM



Page 4

Item ID:	D3798-042	Accept		Setup	Start	
Revision ID:	B				Stop	
Item Name:	Spacepod Floor					
Start Date:	10/14/2009	Start Qty:	3.00			
Required Date:	10/19/2009	Req'd Qty:	3.00			
Reference:						

Approvals:	Process Plan:	Date:	Tooling:	Date:
	QC:	Date:	SPC (Y/N):	Date:

Run	Start	
	Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
180  QC Quality Control	QC5- Inspect part completeness to step on W/O  Memo	0.00  0.00							
190  Powdercoat Powder Coating	Black Sandtex(Ref:4.3.5.7) per QSI005 4.3  Memo POWDER COAT: Start Time: 9:15AM Oven Temperature: 32097 Finish Time: 9:45AM	0.00  0.00							
200  QC Quality Control	QC3- Inspect Part Finish  Memo	0.00  0.00							

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



**Work Order ID 52805**

October 14, 2009 11:36:10 AM

Page 5

Item ID: D3798-042

Accept

Revision ID: B

Item Name: Spacepod Floor

Start Date: 10/14/2009 Start Qty: 3.00

Required Date: 10/19/2009 Req'd Qty: 3.00

Reference:

Cust Item ID:

Customer:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

210

0.00



Small Fab

Memo

0.00

Small Fab

1-Install foam as per dwg D3798 using contact cement

A/R Contact Cement batch: 112983

2- Trim foam if necessary

PT 09 '10 -26

220

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

=> 8 Oct 10 / 26(2042)  
(3)

230

Identify as per dwg & Stock Location: 2413

0.00



Packaging

Memo

0.00

Packaging

PC 19/10/26 (3)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**Work Order ID 52805**

October 14, 2009 11:36:10 AM



Page 6

Item ID: D3798-042

Accept



Setup Start



Revision ID: B

Stop



Item Name: Spacepod Floor

Start Date: 10/14/2009 Start Qty: 3.00



Cust Item ID:

Required Date: 10/19/2009 Req'd Qty: 3.00



Customer:

Reference:

Approvals:

Process Plan: \_\_\_\_\_

Date: \_\_\_\_\_

Tooling: \_\_\_\_\_

Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_

Date: \_\_\_\_\_

SPC (Y/N): \_\_\_\_\_

Date: \_\_\_\_\_

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run HoursDraw  
NumberDraw  
Rev.Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

240

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/10/28

PL 09-10-26

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

October 14, 2009 11:36:10 AM

Page 1 / 1

Work Order ID: 52805



Parent Item: D3798-042RevA



Parent Item Name: Spacepod Floor

Start Date: 10/14/2009

Required Date: 10/19/2009

Comments:

Start Qty: 3.00

Required Qty: 3.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M6061T6S.050  6061-T6 .050 Sheet		Purchased	No			100	sf	164.5716	27.7705			
												129-10-13

Warehouse  
Location

Loc Qty

Loc Code

Main Warehouse

MAT

164.5715

110791

34.5715

112567

128

17349

2

112867

D3798-5  
  
Reinforcement

Manufactured No

170

Each

0.0000

3.0000

B52807



EP09/10/16

MS20426AD4-SH

Purchased No

170

Each

0.0000

99.0000

M15541



EP09/10/16

Rivet

D3798-3RevA

Manufactured No

210

Each

5.0000

3.0000

B52808 RT 09-10-26



Spacepod Floor Foam

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

5

46206

1

51098

4

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

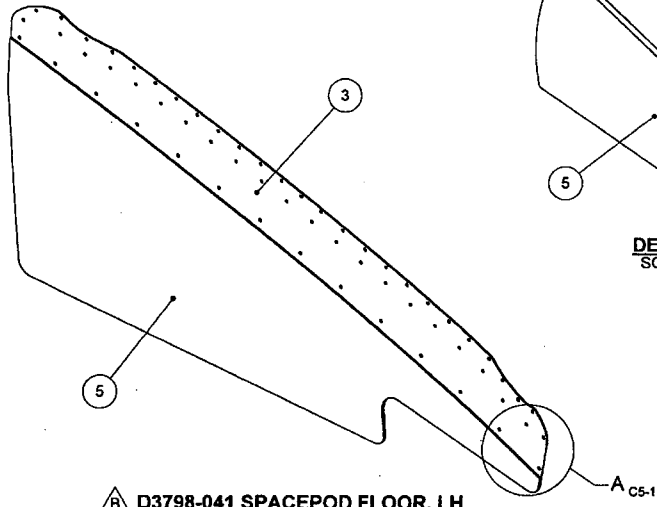
Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

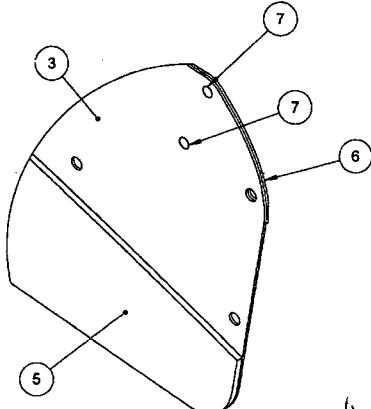
**NOTE:** Date & initial all entries

RELEASE  
2009-10-13

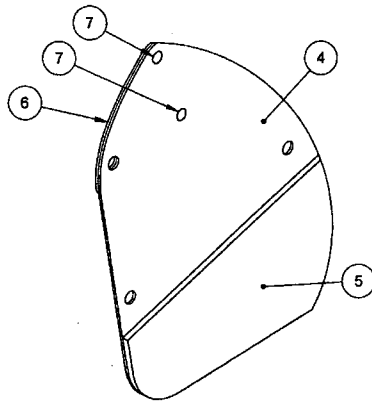
ITEM NO.	QTY. -041	QTY. -042	PART NUMBER	DESCRIPTION
1	X		D3798-041	SPACEPOD FLOOR ASSEMBLY, LH
2		X	D3798-042	SPACEPOD FLOOR ASSEMBLY, RH
3	1		D3798-1	SPACEPOD FLOOR
4		1	D3798-2	SPACEPOD FLOOR
5	1	1	D3798-3	SPACEPOD FLOOR FOAM
6	1	1	D3798-5	REINFORCEMENT
7	33	33	MS20426AD4-3	RIVET



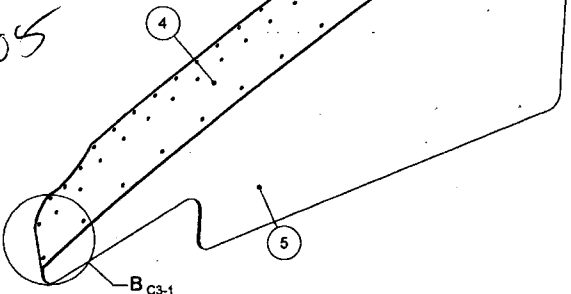
**A D3798-041 SPACEPOD FLOOR, LH**



**DETAIL A A6-1  
SCALE 4X**



**DETAIL B B3-1  
SCALE 4X**



**B D3798-042 SPACEPOD FLOOR, RH**

**NOTES:**

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT BLACK SANDEX (4.3.5.7) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3798-041/-042 USING WHITE FINE POINT PERMANENT MARKER
- 7) WEIGHT: D3798-041 - 5.0 lbs  
D3798-042 - 5.0 lbs

- B) ASSEMBLY INSTRUCTIONS**
- RIVET D3798-5 REINFORCEMENT TO D3798-1/-2 SPACEPOD FLOOR USING RIVETS AS INDICATED
  - POWDER COAT PER NOTE 2
  - INSTALL D3798-3 FOAM AS INDICATED USING CONTACT CEMENT. TRIM TO FIT.

B	ADD -5 (SHEET 4); REVISE -041/-042; ADD ASSEMBLY INSTRUCTIONS (NOTE 8)	HS	09.10.08
A	NEW ISSUE	HS	08.10.20
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	09.10.08		

**DART AEROSPACE LTD**  
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. **D3798** REV. B  
SHEET 1 OF 5

TITLE **SPACEPOD FLOOR** SCALE NTS

COPYRIGHT © 2008 BY DART AEROSPACE LTD  
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

